

Work Order ID 56271

Wednesday, February 17, 2010 11:05:43 AM

Page 1

Item ID: D350-588-011

Accept

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 2/18/2010 Start Qty: 5.00

Required Date: 3/4/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-2-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

10/02/24

MF 10/02/23

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Pick 10/4/24

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

10/02/24

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-588-011

Location: _____

PPP Rev: _____

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/02/24 (5)

10/02/24

MF 10-2-24

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:M 04.08.31 Added D2690-17 BKJ/JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R7		Purchased	No			120	Each	100.0000	10.0000			
--------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

Screw

Warehouse
Location

Main Warehouse

ST	100
104394	3
113064	77
113749	20

AN526C832R8		Purchased	No			120	Each	184.0000	40.0000			
-------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

Screw

Warehouse
Location

Main Warehouse

ST	184
108335	
113595	183

1113067

1113595

113595

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AN526C832R9	84	Purchased	No			120	Each	524.0000	40.0000			



Screw

[Handwritten signature]

Warehouse
Location

Main Warehouse

ST

107376
108377
108928
110372
110915
111916
112492
113595
113840
113845

Loc Qty

524
51
5
14
8
1
1
4
40
200
200

Loc Code

[Handwritten 'R' and 'Q' with arrows pointing to quantities]

113595 324
113840 84

AN960JD10

Purchased

No

120

Each

0.0000

20.0000



Washer



[Handwritten: M113288 1610/24/05]

NA5114900 3635

DS-1-017

[Handwritten signature]

Dart Aerospace Ltd

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AN960JD8 Washer		Purchased	No			120	Each	624.0000	120.0000			
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8/5

NAS1149 D-8 325

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	624	
----	-----	--

107091	9	
--------	---	--

108335	11	
--------	----	--

110382	48	
--------	----	--

110917	3	
--------	---	--

111578	60	
--------	----	--

112385	493	
--------	-----	--

M112385

[Signature]

*

Q.S.I 017

[Signature]

D2143 Hinge Bracket		Manufactured	No			120	Each	43.0000	5.0000			
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8/5

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	17	
----	----	--

37739	17	
-------	----	--

Main Warehouse

ST198	26	
-------	----	--

55323	26	
-------	----	--

37739

[Signature] 10/2/2010

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Start Qty: 5.00

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D2144 Hinge Bracket		Manufactured	No			120	Each	68.0000	5.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2

41174 2

Main Warehouse

ST198 66

55061 14

55179 52

41174 14

55061 44

D2150

Packer Doubler, Hinge

Manufactured No

120 Each 86.0000 10.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST7 86

55016 32

55178 54

55066

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Start Qty: 5.00

Required Qty: 5.00

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D2151		Manufactured	No			120	Each	74.0000	10.0000			
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Packer Doubler, Hinge

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	36	
----	----	--

51407	36	
-------	----	--

Main Warehouse

ST7	38	
-----	----	--

55319	38	
-------	----	--

D2153		Manufactured	No			120	Each	50.0000	5.0000			
-------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Door Prop

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	50	
----	----	--

48373	14	
-------	----	--

55324	36	
-------	----	--

Main Warehouse

ST272	36	
-------	----	--

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Start Qty: 5.00

Required Qty: 5.00

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D2154		Manufactured	No			120	Each	17.0000	5.0000			
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Stud Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST007

17

44890

17

D2237

Manufactured No

120

Each

114.0000

10.0000



Striker Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

55006

30

Main Warehouse

ST010

52

46162

5

55312

47

Main Warehouse

ST022

32

52327

32

W/O:		WORK ORDER CHANGES					
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Start Qty: 5.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2461		Manufactured	No			120	f	579.4940	38.1579			



Neoprene "D" Seal

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 79.49398421

34304 14.234

39782 65.2599842

Main Warehouse

ST422 500

55054 500

55054

cut 1 X 87.00"

D2463

Manufactured No

120 f

833.8310 38.1579



Seal

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 67.8752

31350 1.8278

34305 18.25

43841 45.2974

50075 2.5

Main Warehouse

ST404 765.9557896

50075 265.95579

55561 500

50075

cut 1 X 87.00"

Wednesday, February 17, 2010 11:05:43 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2583 Latch Bracket		Manufactured	No			120	Each	69.0000	10.0000			

Warehouse
Location

Main Warehouse

ST018 69
36043 2
53889 12
55321 55

Loc Qty
Loc Code

55321

D2585
Mounting Channel

Manufactured No

120 Each 123.0000 10.0000

Warehouse
Location

Main Warehouse

ST 2
51526 2
Main Warehouse
ST018 121
45888 2
53798 59
55313 60

Loc Qty
Loc Code

53798

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D2586
Door Latch

Manufactured No

120 Each 60.0000 10.0000



Warehouse
Location

Main Warehouse

ST 60

45554 1

50213 59

120 Each 37.0000 5.0000



Warehouse
Location

Main Warehouse

ST018 37

48647 37

120 Each 42.0000 5.0000



D2587
Door Slug, 350 Hinge

Manufactured No

Warehouse
Location

Main Warehouse

ST019 42

46840 2

50378 40

D2589
Keys, Key Chain, 350 Hinge

Manufactured No

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Shop Packet Print

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D2690-17

Manufactured

No

120

Each

17.0000

5.0000

Cable

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

17

50666

7

55330

10

D2857-1

Manufactured

No

120

Each

48.0000

5.0000

Hinge Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST026

48

41166

7

45788

1

53464

7

55019

33

W/O:		WORK ORDER CHANGES					
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D2857-2 Manufactured No

120 Each 45.0000

5.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

45

53465

12

55020

33

D2858-1 Manufactured No

120 Each 27.0000

5.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

27

45798

15

55062

12

D2858-2 Manufactured No

120 Each 19.0000

5.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

19

45799

7

55063

12

53465 4x
55020 2x

45798

45799

Rec'd 2/24/10 (5)

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FG-778150-550-ROL

Purchased

No

120

sf

2,441.000

5.0000



7781 9oz Glass 50"x125yd

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

1775

113905

1775

Main Warehouse

ST

666

108932

23

111166

643

M111666

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

7,333.000

60.0000



RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7333

104374

3333

110398

4000

M104374

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:43 AM

Work Order ID: 56271

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:ML:04.08.31 Added D2690-17 KJ/JLM

Start Qty: 5.00


Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-5 18X 		Purchased	No			120	Each	1,889.000	90.0000	✓		
Rivet, Universal Head												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1889
106918 50
111916 1839

MS21042L08 18X 		Purchased	No			120	Each	646.0000	90.0000	✓		
Nut												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 646
110002 24
111889 30
112243 43
112492 24
112612 1
112794 8
113595 116
113749 400

M114918 18X
M111916 76X

✓ 10/2/24 5

M113595 13
M113749 77X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

• Picklist Print

Wednesday, February 17, 2010 11:05:43 AM

Work Order ID: 56271



Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: M1104.08.31 Added D2690-17 KJ/JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21042L3	4x	Purchased	No			120	Each	2,665.000	20.0000			
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Nut

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	2659	
----	------	--

110844	35	
--------	----	--

111274	27	
--------	----	--

111668	52	
--------	----	--

112314	289	
--------	-----	--

112385	498	
--------	-----	--

113523	58	
--------	----	--

113537	700	
--------	-----	--

113644	1000	
--------	------	--

Main Warehouse

ST139	6	
-------	---	--

111668	6	
--------	---	--

MS27039-08-11 2x Purchased

No

120

Each

98.0000

10.0000



Screw

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	98	
----	----	--

111977	48	
--------	----	--

113749	50	
--------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:43 AM

Work Order ID: 56271



Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: M04.08.31 Added D2690-17 KJ/JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS27039-1-15

Purchased

No

120

Each

124.0000

10.0000



Screw



Rec'd 2/24 (5)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

124

106903

3

108169

4

109321

4

111916

13

112794

100

112794

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10 /	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237 /	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587 /	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2 /	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2 /	UPPER HINGE BRACKET
8	8	AN526C832R8 /	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08 /	NUT (or MS21042-08)
4	4	MS21042L3 /	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries